Work Orde Wednesday, July			1		*121	1839*						Page	1
Revision ID:	D3414-041	a.r.			Accept	*N900	<b>040</b>	100	<b>)*</b> \$	Setup Sta		S1* S2*	
	Lug 7/02/14 7/02/14		Qty: 8.00 Qty: 8.00	*9* *8*	9	Cust Item I Customer:	D:				· "IŅ	<b>5</b> /"	
Approvals:	Process Pl	an: N	11 5	Date: 14-07-04	Tooling:	Da	ate:	_	F	Run Sta	rt *N	R1*	
approvais.	QC:			Date:	SPC (Y/N):		ate:			Sto	<sup>p</sup> *N	R2*	
Sequence ID/ Work Center II	<b>D</b>	Operat Descrip			Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Re	vision Nb	r	<u> </u>									
D3414	Re	v C											
100					0.00								/
*100* Waterjet FLOW CNC Waterj	et .		Memo 1-Cut as p Dwg Rev: Prog Rev:		0.00				9_		B/De	14/04/	15
			riog kev:	<u> </u>									

0.00

0.00

2-Deburr if necessary

QC2- Inspect parts off machine FAI/FAIB

Memo

110

Quality Control

DQA:			Date:										DART
QA Closed:			Date:			WORK ORDER NON	-C(	ONFO	RMANCE / UF		ork Order up	odate only	AEROSPACE
QA Closed.			Date.										
Work Orde	er:					DISPOSITION				AGAINST DI	EPARTMENT, -	/PRUCE33	_
	•		-			Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	Νο	<del></del>				Scrap			Machining	Small Fab	-1	d. Eng. Coor.	Quality
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Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC Inspector
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	Н	Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Un	qualified	Part Lost/Mi	ssing	Weld
	П	Cuffs		•		Contamination	Г	Instruct	tions Incomplete/U	nclear	Part Moved		Wrong Stock Pulled
	-	Crushing				Countersink		  Misalig	ned/off center		Positioned V	Vrong	_
	-	Heat Trea	at			Cut Too Short		Mislabe			Power Loss/	Surge	Other
	П	Inspectio	n Strip in	Tube		Drawing		Misrea	d				
	$\vdash$	Marks/Ch				Drill Holes		Off-set					
		Turning S	equence			Finish		Out of	Calibration				
		Wave/Tw	ist in Tub	e		Fit/Function		Out of:	Sequence				

Work Ord Wednesday, July				*121	1839*							Page	2
Item ID: Revision ID:	D3414-041			Accept	*N900	0040	100	)*	Setup	Start Stop	171	S1*	
Item Name: Start Date: Required Date: Reference:	Lug 7/02/14 7/02/14	Start Qty: 8.00 Req'd Qty: 8.00	*8 *8	* 7	Cust Item Customer:						··IVI	S2*	
Approvals:	Process Pla	ın:	Date:	Tooling:	D	ate:	_		Run	Start	~1/1	R1*	
••	QC:		Date:	<b>SPC</b> (Y/N):	D	ate:				Stop	*N	R2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp	
120		QC8- Inspect parts - seco	ond check	0.00				_				Das <b>38</b>	
*1 20* QC		Memo		0.00				9				9-89	<u>1</u> 4-9-17
Quality Control		·											
130				0.00			DAS 30						. [
*1.30* Brake NC		Memo		0.00			9-89	9	<del></del>			14	,09117

MAL 14-11-19

0.00

0.00

Memo 1-Deburr

Memo

2-Form using DT8254 as per Dwg D3414

Brake NC

\*140\* Large Fab

Large Fab

140

DQA:			Date:		_									DART
QA Closed:			Date:			WORK ORDER NON	-C(	ONFO	RMANCE / UPDATE	We	ork Order up	date only		AEROSPACE
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Work Ord	er: ˌ										•	-		🗂
						Rework		l	Skid-tube Crosstube	-	0	Water Jet		Engineering
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		Crimp/Kii	nk/Ripple	/Wave		Burrs		Inspecti	on Incomplete/Unqualified	П	Part Lost/Mi	ssing		Weld
	<u> </u>	Cuffs		•		Contamination		Instruct	ions Incomplete/Unclear	П	Part Moved	-		Wrong Stock Pulled
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		Marks/Cl	natter			Drill Holes		Off-set						
		Turning S	equence			Finish		Out of 0	Calibration					
		Wave/Tw	ist in Tub	e		Fit/Function		Out of S	Sequence					

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Wednesday, Jul				*121	1839*			·				Page :	3
Item ID: Revision ID:	D3414-041			Accept	*N900	040	110	<b>)</b> *	Setup	Start Stop	···IV.	S1*	
Item Name: Start Date: Required Date Reference:	Lug 7/02/14 : 7/02/14	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*	7	Cust Item I Customer:	ID:					"IN.	S2*	
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	QC:		Date:	_ SPC (Y/N):	Da	ate:				Stop	*NI	₹2	
Sequence ID/ Work Center I 150 *150* QC Quality Control	T <b>D</b>	Operation Description QC9- Inspect visual per Memo	QS1004- Fusion Welds	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Qty	/	Reject Number 1 9 2014	Insp. Stamp DAS 24 9-89	
160 *160* QC Quality Control		QC5- Inspect part complete Memo	leteness to step on W/O	0.00				9		NOV	1 9 201	DAS 24 9-89	
170 *170* Powdercoat Powder Coating		White Gloss(Ref.4.3.5.1  Memo START TIM OVEN TEM FINISH TIM	9 808 4E: 8 100 MPERATURE: 400	0.00 0.00				9	\$	/_/L	1-11-5	<b>Y</b>	DAS 34

DQA:			Date:										DAF	2T
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QA Closed.		· · ·	Date.					-			······································			
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	,				_	Rework			Skid-tube C	Crosstube	7	Water Jet	Engineering	
Part N	lo.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
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Work Orde Wednesday, July				*121	1839*							Page	4
Item ID: Revision ID: Item Name:	D3414-041			Accept	*N900	040	1100	)*	Setup	Start Stop	IA	S1* S2*	
Start Date: Required Date: Reference:	Lug 7/02/14 7/02/14	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*	9	Cust Item :	ID:						<b>ハノ</b> "	
Approvals:	Process Pla	ın:	Date:	Tooling:	D	ate:			Run	Start	*N	R1*	
• •	QC:		Date:	<b>SPC</b> (Y/N):	D	ate:				Stop	*N	R2*	
Sequence ID/ Work Center II	D	Operation Description QC3- Inspect Part Finish		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp DAS	
*1 A \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \		Memo		0.00				9	_			NOV 2 0	2014
190		Identify as per dwg & Sto	ck Location	31 0.00				$\bigcirc$		_			
*100* Packaging Packaging		Memo		0.00				91		<i>−</i> ∂ <sub>)</sub>	D 14	!-//-	)e
200		QC21- Final Inspection -	Work Order Release	0.00						,	. 1	/	) /i

0.00

Memo

\*200\*

Quality Control

14/11/20 Sf Mu-11-20

DQA:			_ Date:						·	· 					TOART
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Work Orde	er: _						.			_	_	•			
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Part <b>N</b>	١٥.					Scrap			Machining noforming	Small Fab Finishing	$\dashv$ $\Box$		<ul><li>d. Eng. Coor.</li><li>re/Packaging</li></ul>	-	Quality Other
NCR I	do.					Use-as-is Suspected Unapproved			Large Fab	Composite	- \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \	C/3(0)	Supplier		
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	_	Heat Trea			<u> </u>	Cut Too Short	$\vdash$	Mislabe		L	Powe	r LOSS/	Surge		Other
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	]	Wave/Tw	vist in Tub	e e		Fit/Function		Out or s	Sequence						

**Picklist Print** 

Wednesday, July 02, 2014 3:36:19 PM

Work Order ID: 121839

\*121839\*

Parent Item:

D3414-041

\*D3414-041\*

Parent Item Name: Lug

**Start Date:** 7/02/14

Required Date: 7/02/14

Page 1

Start Qty: 8.00

Required Qty: 8.00

**Comments:** 

IPP A05.09.13New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date St Issued	tatus
M304S12GA		Purchased	No			100	sf	109.6300	0.155	2		,	,
*M304S12 304/316 0.100" Sheet	PGA*								**			DC 14/04	4/12
				Location		Loc	<u>Oty</u>	Loc Code					
				MAT019		10	9.63						
					113062	7	6.13		_		-		
					113077		19		_		-		
				4	n126309		14.5	•	_	1-5			
D3414-3		Manufactured	No			140	Each	32.0000	1	8			
*D3414-3 <sup>3</sup>	*								**				

Location Loc Qty Loc Code WA001 32 114975 89 32

9 14-11-19 MAL

Lug

DQA:			Date:										AG"	RT
						WORK ORDER NON-	-C(	ONFO	RMANCE / UP			,, , <u>,</u>	AEROS	PACE
QA Closed:			Date:					1		<u></u>	Vork Order up	date only		
Work Ord	or.					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS		
WOIK OIG	٠٠٠.					Rework			Skid-tube	Crosstube		Water Jet	Engineering	
Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality	_
	•				_	Use-as-is			noforming	Finishing	Rec/Sto	re/Packaging	Othe	r□
NCR I	lo.					Suspected Unapproved			Large Fab	Composite		Supplier		
Root		, and the second			Desci	ription of work order update	1	nitial	Acti		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC Inspec	ctor
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Supplier														0
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		Bending			Г	Bend		Folio/F	Program	Г	Outside Dim	ensions	Pressure/Force	ed
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		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	સ [	Temperature/	Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Und	qualified	Part Lost/Mi	ssing	Weld	
		Cuffs				Contamination		Instruct	tions Incomplete/U	nclear	Part Moved		Wrong Stock P	ulled
		Crushing				Countersink		]Misalig	ned/off center		Positioned V	Vrong		
		Heat Trea	at			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other	
		Inspectio	n Strip in	Tube		Drawing		Misread	d					
		Marks/Ch	natter			Drill Holes		Off-set						
		Turning S	equence			Finish		Out of	Calibration		<u></u>			
		Wave/Tw	ist in Tub	e		Fit/Function		Out of	Sequence					

DART AEROSPACE LTD	Work Order:	121839
Description: Lug Bracket	Part Number:	D3414-1
Inspection Dwg: D3414 Rev: C		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.313	+0.006/-0.001	,314			V=JEM-01	<del></del>
1.19	+/-0.030	1.19				-
1.00	+/-0.030	1.66				
3.38	+/-0.030	3.375				<u> </u>
5.350	+/-0.010	5.350				
6.23	+/-0.030	6.22				
2.500	+/-0.010	2.500				
0.37	+/-0.030	.37			·	
0.100	+/-0.010	-101				
			8-8			* * * **

Measured by: De/R

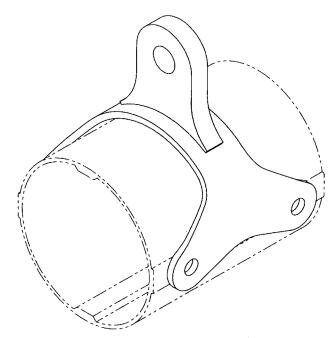
Date: /4/09/12

	3 30
Audited by:	<b>9- 9-8</b> 9
Date:	14-9-12

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	08.02.28	New Issue P/O D3414-041	KJ/DD	
В	09.05.27	Dimensions updated per Dwg Rev B	KJ (a	
С	09.10.16	Dwg Rev updated to Rev C	KJ XI	N/

ITEM QTY. No041		PART NUMBER	DESCRIPTION		
1	Х	D3414-041	LUG ASSEMBLY		
2	1	D3414-1	LUG BRACKET		
3	1	D3414-3	LUG		



D3414-041 LUG ASSEMBLY

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.52 lbs

SHOP COPY RETURN TO ENGINEERING INCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 121839 M LJ 1407-04

С	BREAK SHARP EDGES FOR -3 NOW 0.030-0.060 WAS 0.010-0.030 (ZN A7-3)			СР	09.06.17
В	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERED TO "B" SIZE BORDER. FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). FLAT SPOTS REMOVED FROM -1 (PART NOW "SHAPED) FOR EASE OF MANUFACTURE. B7-3 ADDED TO LERANCE TO 3.230 DIM. C2-3 1.12 DIM WAS 1.20.				08.09.23
Α	NEW IS	NEW ISSUE			05.03.16
REV.	DESCRIPTION			BY	DATE
DESIGN CP		₫₽	DART AEROSPACE LTD		
		QP	HAWKESBURY, ONTARI		
CHECKED			DRAWING NO.		REV. C
MFG. APPR.		En	↑D3414		SHEET 1 OF
APPROVED DE APPR.		W.	TITLE		SCALE
		<b>a#</b>	LUG ASSEMBLY		NTS

3

8

09.06.17

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NTS

